

Claims

What is claimed is:

1. A suction roll seal strip, which is
manufactured from a mixture, which mostly consists of
5 nitrile rubber and graphite, characterized in that the
mixture includes wax.

2. A seal strip according to Claim 1,
characterized in that the amount of wax in the mixture
is set in such a way that the flexibility of the seal
10 strip permits it to be bent onto a reel, the radius of
which is less than 130 cm.

3. A method for manufacturing a suction roll seal
strip from a mixture, which mostly consists of nitrile
rubber and graphite, and from which mixture a seal blank
15 is formed, which is hardened at a chosen temperature,
characterized in that the mixture to be hardened
includes wax.

4. A method according to Claim 3, characterized
in that the amount of wax is 1 - 15 %.

20 5. A method according to Claim 4, characterized
in that the amount of wax is 2 - 4 %.

6. A method according to Claim 3, characterized
in that the amounts of nitrile rubber and graphite are
within the ranges:
25 nitrile rubber 30 - 60 % volume, and graphite 30 - 60 %
volume.

7. A method according to Claim 3, characterized
in that the hardening temperature is in the range 140 -

160°C, and the hardening time is in the range 3 - 5 hours.

8. A method according to Claim 7, characterized in that the hardening temperature is in the range 145 -
5 155°.

9. A method according to Claim 3, characterized in that the mass includes 1 - 15 % sulphur or peroxide.

10. A method according to Claim 3, characterized in that the graphite used is natural graphite.

10 11. A method according to Claim 3, characterized in that the graphite used is synthetic graphite.

12. A method according to Claim 3, characterized in that the melting point of the wax used is more than 100°C.

15 13. A method according to Claim 12, characterized in that the melting point of the wax used is within the range 110 - 150°C.

14. A method according to Claim 3, characterized in that the amount of wax is arranged to create
20 flexibility in the seal strip, which will permit it to be rolled onto a reel with a radius of less than 1.5 m.